

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009830**Date Inspected:** 19-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector randomly observed the following work in progress in Bay 10:

FCAW repair welding of weld joint NSTL3-3B/K-84A located inside PCMK north tower, lift 3, skin A to skin B approximately 1 meter above the top of diaphragm 109.5M. Welder was identified as 040533. ZPMC QC was identified as CWI Chen Ying Xin (QC1). The welding variables recorded by QC1 appeared to comply with WPS-345-FCAW-2G(2F)-repair listed on ZPMC repair order T-WR2016. Also present at this location and appearing to be monitoring the welding and obtaining data was ABF Representative Zhang Qin Jian.

FCAW repair welding of weld joint NSTL3-3B/K-84A located inside PCMK north tower, lift 3, skin A to skin B at the bottom of diaphragm 102.5M. Welder was identified as 040343. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-345-FCAW-2G(2F)-repair listed on ZPMC repair order T-WR2016. Also present at this location and appearing to be monitoring the welding and obtaining data was ABF Representative Zhang Qin Jian.

FCAW repair welding of weld joint NSTL3-3B/K-84A located inside PCMK north tower, lift 3, skin A to skin B between the bottom of diaphragm 95M and the top of diaphragm 99M. Welder was identified as 053869. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with

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WPS-345-FCAW-2G(2F)-repair listed on ZPMC repair order T-WR2016. Also present at this location and appearing to be monitoring the welding and obtaining data was ABF Representative Zhang Qin Jian.

FCAW repair welding of weld joint NSTL3-3B/K-84A located inside PCMK north tower, lift 3, skin A to skin B between the bottom of diaphragm 85.25M and the top of diaphragm 89M. Welder was identified as 053870. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-345-FCAW-2G(2F)-repair listed on ZPMC repair order T-WR2016. Also present at this location and appearing to be monitoring the welding and obtaining data was ABF Representative Zhang Qin Jian.

Bay 11

This QA Inspector randomly observed the following work in progress in Bay 11:

SAW welding of weld joint ESTL4-2B/L-59A located outside PCMK east tower, lift 4, skin B to skin C at the lower and upper work piece position areas (rotation fenders). Welders were identified respectively as 202756, 042195. ZPMC QC was identified as CWI Li Hongfei (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-2221-C-U2b-S-2.

Finish drilling of 30mm holes through skin plates B and C previously, partially drilled holes on both sides of the west tower, lift 1/lift2 joint. The doubler plates originally used to perform the partial drilling had been removed.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Goulet,George	Quality Assurance Inspector
<b>Reviewed By:</b>	Dawson,Paul	QA Reviewer

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